

Work Order ID 138891

138891

Page 1

Friday, November 13, 2015 11:35:49 AM

Item ID: D3371-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tail Rotor Pedal Lock
 Start Date: 11/27/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/27/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MJS Date: NOV 16 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3371	Rev B								

120 0.00
120 Small Fab 1 FF NOV 25 2015
 Small Fab Memo 0.02
 Small Fab

ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.
 2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
 3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
 4- Assemble lock mechanism and cam and install decal as per Dwg D3371.
 Apply locktite to lock body nut.
 Qty Part Number Description Batch
 A/R 262 Locktite M132202

130 0.00
130 Small Fab 1 FF NOV 25 2015
 Small Fab Memo 0.01
 Small Fab Assemble lanyard to cyclic sock as per Dwg D3384
 Identify as D3384-045

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

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Item ID: D3371-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Tail Rotor Pedal Lock

Start Date: 11/27/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 11/27/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Work Order ID 138891***138891***

Page 3

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Item ID: D3371-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tail Rotor Pedal Lock

Start Date: 11/27/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/27/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

 20151125

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Friday, November 13, 2015 11:35:48 AM

Page 1

Work Order ID: 138891

138891

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 11/27/2015

Required Date: 11/27/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

238-028		Purchased	No			120	Each	94.0000	2	2			
238-028									**	<u>5</u>			NOV 25 2015
3/16" Dowel Pin .5" long													

Location	Loc Qty	Loc Code
GA	9	
M103114	9	
ST568	85	
<u>M132062</u>	85	

AN526C832R6		Purchased	No			120	Each	64.0000	4	4			
AN526C832R6									**	<u>55</u>			NOV 25 2015
Screw													

Location	Loc Qty	Loc Code
GA	64	
<u>m131379</u>	64	

CBL-1240		Purchased	No			130	f	518.7500	1.6666	1.754316			
CBL-1240									**	<u>FF</u>			NOV 25 2015
Cable													

Location	Loc Qty	Loc Code
GA	518.75	
m130006	3	
<u>m130035</u>	20.75	
m132518	495	

1.754

DQA: _____ Date: _____



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Picklist Print

Page 2

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Work Order ID: 138891

138891

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 11/27/2015

Required Date: 11/27/2015

Start Qty: 1.00

Required Qty: 1.00

CBL-460

Purchased

No

130

Each

100.0000

2

2

CBI -460

Loop Sleeve

**

FF

NOV 25 2015

Location

Loc Qty

Loc Code

GA

100

m131619

5

m132518

16

m133240

29

m133344

50

2

D3371-1

Manufactured

No

120

Each

0.0000

1

1

D3371-1

Pedal Lock Base

D3371-3

Manufactured

No

120

Each

4.0000

1

1

D3371-3

Pedal Lock Cover

**

FF

NOV 25 2015

133991

**

Location

Loc Qty

Loc Code

ST498

4

104353

4

D3373-7

Manufactured

No

120

Each

17.0000

1

1

D3373-7

Cam Lock

**

Location

Loc Qty

Loc Code

GA

5

101874

5

ST033

12

123528

1

94791

11

NOV 25 2015

NOV 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube</td><td style="width:12.5%;">Cross tube</td><td style="width:12.5%;">Water Jet</td><td style="width:12.5%;">Engineering</td></tr> <tr> <td>Machining</td><td>Small Fab</td><td>Prod. Eng. Coord.</td><td>Quality</td></tr> <tr> <td>Thermoforming</td><td>Finishing</td><td>Rec/Store/Packaging</td><td>Other</td></tr> <tr> <td>Large Fab</td><td>Composite</td><td>Supplier</td><td></td></tr> </table>						Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality	Thermoforming	Finishing	Rec/Store/Packaging	Other	Large Fab	Composite	Supplier	
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Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐														
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐														
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐														
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐														
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐														
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐														
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :																					
Misidentified	☐	Past Due	☐																						

Picklist Print

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Work Order ID: 138891

138891

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 11/27/2015

Required Date: 11/27/2015

Start Qty: 1.00

Required Qty: 1.00

D3384-1 Manufactured No 130 Each 11.0000 1 1

D3384-1

Cyclic Sock

DAG

6

9-89

Location Loc Qty Loc Code

ST500 11

133088 1

134274 10

D3385-3 Manufactured No 120 Each 28.0000 1 1

D3385-3

Hinge

DAG

6

9-89

Location Loc Qty Loc Code

ST034 28

117534 28

HX-81 Purchased No 140 Each 61.0000 1 1

HX-81

1/4"-20 SHCS 3/8" long

DAG

6

9-89

Location Loc Qty Loc Code

ST554 61

123436 61

NAS1149F0463P Purchased No 140 Each 1,116.000 2 2

NAS1149F0463P

Washer

Location Loc Qty Loc Code

ST260a 973

m127832 973

st268 143

m127832 135

m130388 8

DAG

6

9-89

NOV 25 2015

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐								
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval					
Description Work Order Deviation				Disposition				Completed By				
								Lead hand / Supervisor Approval Verification				
												QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY										
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐							
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐							
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐							
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐							
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐							
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐							
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐							
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐							
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐							
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐							
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____										
Misidentified ☐	Past Due ☐											